



Dart Aerospace Ltd.
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881 2 240 000-1
Job Sheet 185307



Part No: 881 2 240 000-1

Job Qty: 5 ea

Part Name: Support Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/24/18

Job Tracking No:

Due Date: 11/23/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 881 2 240 000 Rev. 5 IPP Rev. A 18.10.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Start up Operation	5 Ea	11/23/18	11/23/18	0.00	0.00	Start Up Large Fab-7		EZ
110	Large Fab	5 pcs	11/23/18	11/23/18	0.00	1.25	Large Fab 2		EZ
120	QC	5 pcs	11/23/18	11/23/18	0.00	0.00	QC9		CPC
125	QC	5 pcs	11/23/18	11/23/18	0.00	0.00	QC5		CPC
130	Outsource	5 pcs	11/23/18	11/23/18	0.00	0.00	Outsource4		-
140	Packaging	5 pcs	11/23/18	11/23/18	0.00	0.00	Packaging2		-
150	QC	5 pcs	11/23/18	11/23/18	0.00	0.00	QC6		-
160	Packaging	5 pcs	11/23/18	11/23/18	0.00	0.00	Packaging3-2		-
170	QC21-SA	5 Ea	11/23/18	11/23/18	0.00	0.00	QC21		MLL

Part Op 110 - Weld as per DWG.

Descriptions: 130 - Issue P/O to GROUPE ALTECH; PO - ANODIZE COLOR BLACK, PER IAW MIL-A-8625E TYPE 2
CLASS 2, Water sealant - Material type: 6061T6 - Certificate of Conformity is required

ONSET ANODIZE ON QTY(5) MBL DEC 20/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
881 2 240 000-1A	Tube Support Bottom Part	5 Ea (1 ea)	100-Start up Operation	5136163
881 2 240 000-1B	Tube Support Top Part	5 Ea (1 ea)	100-Start up Operation	5135540

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Start up Operation	881 2 240 000-1A	5	0	0
	881 2 240 000-1B	5	0	0



Container No: S139908



Part: 881 2 240 000-1

Job No: 185307

Serial No/Batch: S139908

Revision: 5

Inspector:

Exp Date:

Instructions:

Date: 12/21/18

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found.

Plex 10/24/18 3:01 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

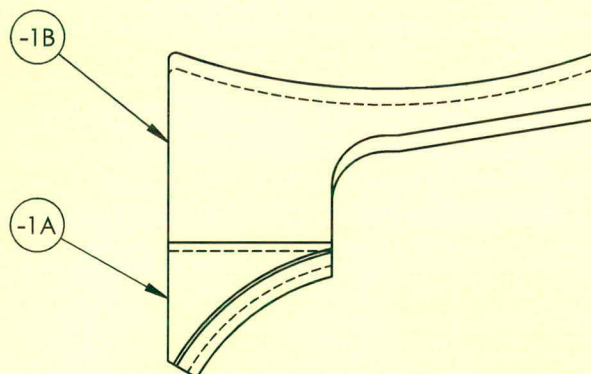
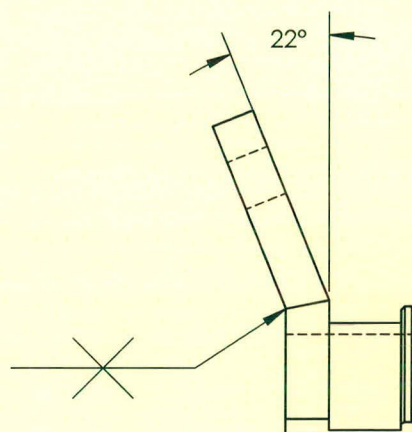
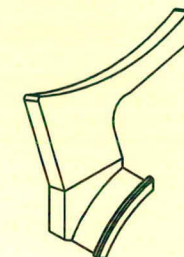
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
				OTHER :							

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REV		ECR	REVISIONS		DESCRIPTION	DATE	INITIAL	APPROVED

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 185307 MWS

18-1024



NOTE:
WELD AS SHOWN, USE 5356 FILLER ROD.

(-1)

SUPPORT WELDMENT

DART AEROSPACE	
TITLE TUBE SUPPORT	
DWG NO. 881 2 240 000-1	REV 5
MAT'L FRTY TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/
MIL-A-8625F, TYPE II, CLASS II	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: COLE	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: MACKOVJAK	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	ARRIEL SA365 OU 350
APPROVED: GILBERT	
SCALE 1:2	DATE 8/5/2003
SHEET 2 OF 4	

